

Date: Tuesday, 17/03/2009 12:47:23 PM
 User: Julie Dawson

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: D2161-205
Job Number	: 46542		
Estimate Number	: 10804		
P.O. Number	:	Part Number	: D2161205 <i>BK</i>
This Issue	: 17/03/2009 S.O. No. :	Drawing Number	: R09-023
Prsht Rev.	: NC	Project Number	:
First Issue	: / / Type : LARGE FAB ASSY	Drawing Revision	:
Previous Run	: 00015	Material	:
Written By	:	Due Date	: 24/03/2009 Qty: 1 Um: Each
Checked & Approved By	: <i>JUD 09.0317</i>		
Comment	:		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2161205	Mirror Bracket, 205
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
 Mirror Bracket, 205
 Original B36467, from D205-563-041 B36467 kit

2.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1
 Strip and remove all paint and powdercoat from the D3161-205 arm with paint stripper.

HL 09-04-23 (X1)

3.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder coat black per QSI005 4.3.5.7

M. *105642*

Start time: *10:30*

Oven temp: *320°*

Finish time: *11:00*

umo, FY

09/04/30

(X1)

4.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-04-30

(X1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 17/03/2009 12:47:24 PM
User: Julie Dawson

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D2161-205

Job Number: 46542

Part Number: D2161205

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Stock item using the new batch #

Location: _____

ST241A

PC 9/5/01 (1)

6.0

QC21

FINAL INSPECTION/W/O RELEASE



09/06/25 JG

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 09-06-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART



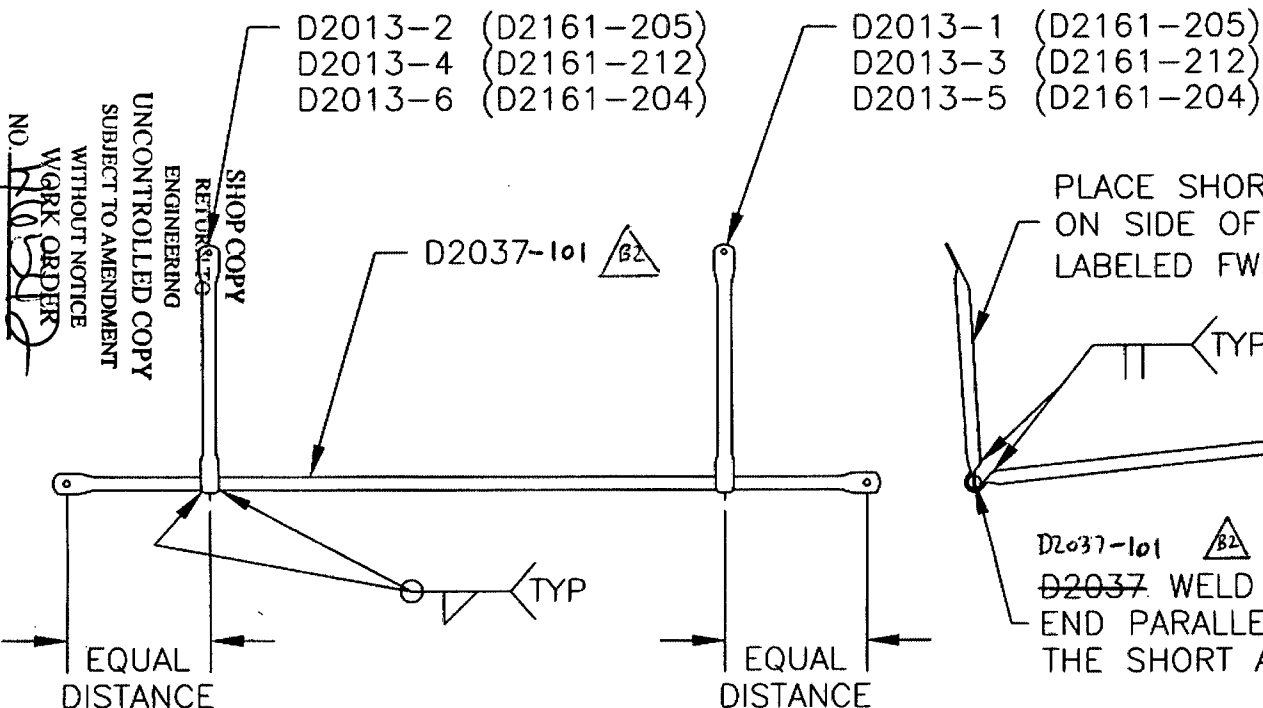
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. B
JB	RT		
CHECKED <i>JE</i>	APPROVED <i>RT</i>	DRAWING NO. D2161	SHEET 1 OF 1
DATE 99.06.07	TITLE MIRROR BRACKET	SCALE NTS	

A	93.04.29	NEW ISSUE
B	99.06.07	REDRAWN FOR CLARITY ADDED -204/-205/-212 DESIGNATIONS
E1	02.03.25	CHANGE FINISH
E2	02.06.14	D2037-101 W/

PLACE SHORTER ARM
ON SIDE OF JIG DT8065
LABELED FWD (TYP)

D2037-101 $\triangle B2$
D2037 WELD FLAT
END PARALLEL TO
THE SHORT ARM

DETAIL OF D2161-204
DETAIL OF D2161-205
DETAIL OF D2161-212



NOTE: WELD ASSEMBLY
USING JIG DT8065

FINISH: ~~POWDER COAT ASSEMBLY BLACK~~
~~CRINKLE (4.3.5.3) PER DART QSI 005 4.3~~
POWDER COAT BLACK SANDTEX (4.3.5.7) PER
DART QSI 005 4.3 $\triangle B1$

RELEASED
KE 99.06.10

Date: Thursday, 28/05/2009 11:05:35 AM

User: Melanie Fauteux

JOB HISTORY : DETAIL

Job Number	: 36467	Customer	: Dart Helicopters Services
Estimate Number	: 10149	DWG Name	: 205 DUAL MIRROR ASSEMBLY
Purchase Order #	:	Part Number	: D205563041
Complete Date	: 28/01/2008 2:08:47	DWG Number	: D2161 REV B2
		Rev.	: B2

DUE DATE	ORDERED	DELIVERED
15/01/2008	4	4

2.0	D2161204-Mirror Bracket, 204	SUB-Component/Sub-job
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DATE	EMPLOYEE	TYPE	Qty			
28/01/2008	DUBE01: Dube, Dominique		4.000		\$594.30	36467A
Subtotal:		CTD:	0		\$594.30	

4.0	D2011103-8" Mirror	INVENTORY ITEM
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DATE	EMPLOYEE	TYPE	Qty		COST	
25/01/2008	DESJ02: Desjardins, Line	D2011103	8.000		\$225.96	Lot # 29690 Qty. 6 Lot # 36506 Qty. 2
Subtotal:		QTD:	0	CTD:	8	\$225.96

6.0	MS27039108-Screw	INVENTORY ITEM
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DATE	EMPLOYEE	TYPE	Qty		COST	
03/01/2008	QUIR01: Quirion, Sonia	MS27039108	16.000		\$1.49	Lot # 105076 Qty. 16
04/01/2008	QUIR01: Quirion, Sonia	MS27039108	-4.000		\$-0.37	Lot # 105076 Qty. -4
25/01/2008	DESJ02: Desjardins, Line	MS27039108	4.000		\$0.37	Lot # 105076 Qty. 4
Subtotal:		QTD:	0	CTD:	16	\$1.49

		TIME	COST
	Machine Time:	0.00	\$0.00
	Labor:	0.00	\$0.00
	Sub-contract (external Op.):		\$0.00
	INVENTORY ITEM:		\$227.45
	SUB-COMPONENT (SUB-JOB):		\$594.30
Total:			\$821.75

COST PER UNIT:	\$205.43
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